

Date: Friday, 05/09/2008 10:07:15 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 BEARPAW INSTALLATION KIT (48")
Job Number : 41855-1	
Estimate Number : 12283	
P.O. Number :	Part Number : D205564011
This Issue : 05/09/2008 S.O. No. :	Drawing Number : D2521
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : J
Previous Run : 40082	Material :
Written By :	Due Date : 30/09/2008
Checked & Approved By : <i>NO 08.9.05</i>	Qty: 8 Um: Eac
Comment : Est F 00.01.20 Changed pick list, MPP 2019, CHG006 EC Est Rev:G 06-08-28 As per Rev E JLM Est Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

- Photocopy blue file and type labels per PPP D205-564-011 CHG008

2.0	MFG ENGINEERING	MFG ENGINEERING
-----	-----------------	-----------------

**Comment:** MFG ENGINEERING

Program Batch Number

3.0	MUHMWB10	UHMW 1" Black
-----	----------	---------------

**Comment:** Qty.: 13.6500 sf(s)/Unit Total : 109.2000 sf(s)

blank: 19.500" x 48.0" x 1.00" thick (+0.030/-0.000) per DSK086-6

Material: Black UHMW 1"

(MUHMWB10)

Batch: *2108645*

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

(2) Bearpaws Make (1) kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2521 Identify as D2521

3-Deburr

*HA 08/10/02**20 08/10/01*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 41855

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 08/10/01 Y.A 08/10/02

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

mf 08/10/02 (2)

7.0

D2182B

Rubber Cushion



Comment: Qty.: 3.7000 f(s)/Unit Total : 29.6000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2182B055 Rubber Cushion

8.0

D2274

Radius Block



Comment: Qty.: 20.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2274 Radius Block

9.0

D2529

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 D2529 Washer

10.0

D2947

Clamp



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Clamp

Pick:

Qty Part Number Description Batch

8 D2947 Clamp

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 41855

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D3544041

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

CLAMP

Batch: _____

12.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Batch: _____

13.0

AN415A

Bolt



Comment: Qty.: 20.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN4-15A Bolt _____

14.0

AN960JD416

Washer



Comment: Qty.: 20.0000 Each(s)/Unit Total : 160.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

20 AN960JD416 Washer _____

15.0

MS21042L4

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 160.0000 Each(s)

Nut

Batch: _____

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 BEARPAW INSTALLATION KIT (48")

Job Number: 41855

Part Number: D205564011

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



DPP42406

8/10/02



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

18.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/02



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-02

DART AEROSPACE LTD		Work Order: 41855
Description: Bearpaw		Part Number: D2521
Inspection Dwg: D2521	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension			Actual Dimension	Accept	Reject	Method of Inspection	Comments
Dim	Min	Max					
A	0.260	0.266	.260				
B	0.90	0.96	.950				
C	0.27	0.330	.300				
D	0.470	0.530	.500				
E	21.740	21.760	21.750				
F	0.72	0.780	.750				
G	0.35	0.410	.380				
H	11.490	11.570	11.500				
I	3.41	3.47	3.400				
J	11.790	11.810	11.800				
K	9.47	9.53	9.500				
L	7.190	7.210	7.200				
M	6.910	6.970	6.940				
N	44.47	44.530	44.500				
O	6.590	6.650	6.620				
P	0.940	0.980	.960				
Q	18.97	19.03	19.00				
R	0.350	0.410	.380				
S	0.740	0.780	.750				
T	0.240	0.280	.270				
U	0.370	0.410	.380				
V	0.740	0.780	.760				
W	0.740	0.780	.760				

Measured by: JCF/4120	Audited by: [Signature]	Prototype Approval: N/A
Date: 08/10/02	Date: 08/10/02	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D205-564-011 & D430-688-011	KJ/RF	
B	05.06.15	Dimensions and tolerances changed	KJ/RF	
C	06.08.31	Dimensions updated per D2521 Rev. J	KJ/JLM [Signature]	[Signature]

DART

DESIGN #	DRAWN BY C.B.	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 1 OF 3
DATE 06.07.28		TITLE 205 BEARPAW	SCALE NTS
A	95.11.28	NEW ISSUE	
B	96.01.11	SHOW BENDING MOVE HOLES	
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING	
D	96.05.14	ADJUSTED BEAR PAW THICKNESS	
E	96.12.18	43.500 WAS 46.750	
F	97.05.07	ADDED REAR POCKET, MOVED HOLES	
G	98.08.06	ADD C'BORE AND CHAMFER EDGES	
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.	
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES	
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE	

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41855

RELEASED

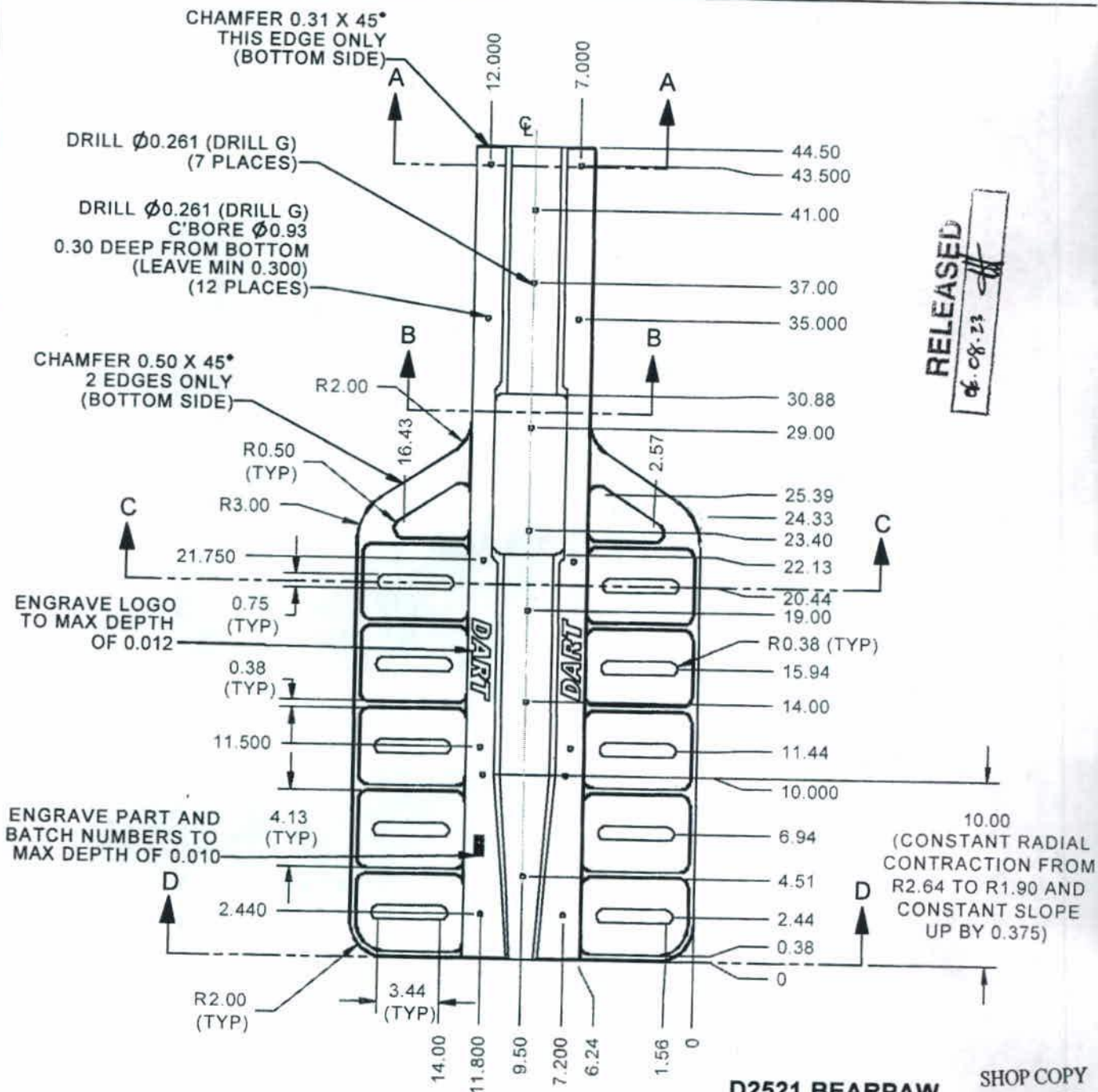
06 08.23 #

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD	
	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV
CP	TH	D2521	SHEET 2 OF
DATE		TITLE	SCALE
06.07.28		205 BEARPAW	1

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

D2521 BEARPAW

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WITHOUT NOTIC

WORK-ORDE

NO. 41855

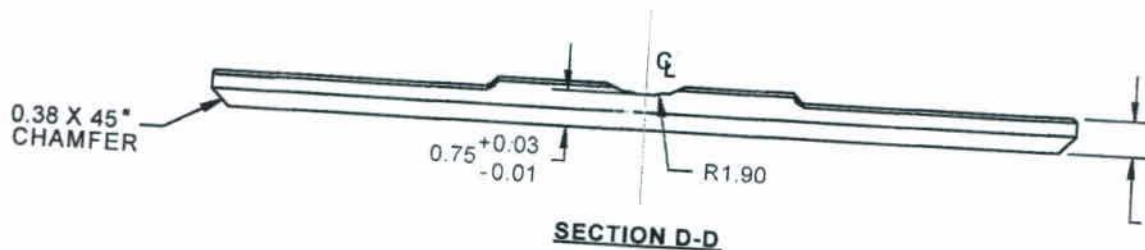
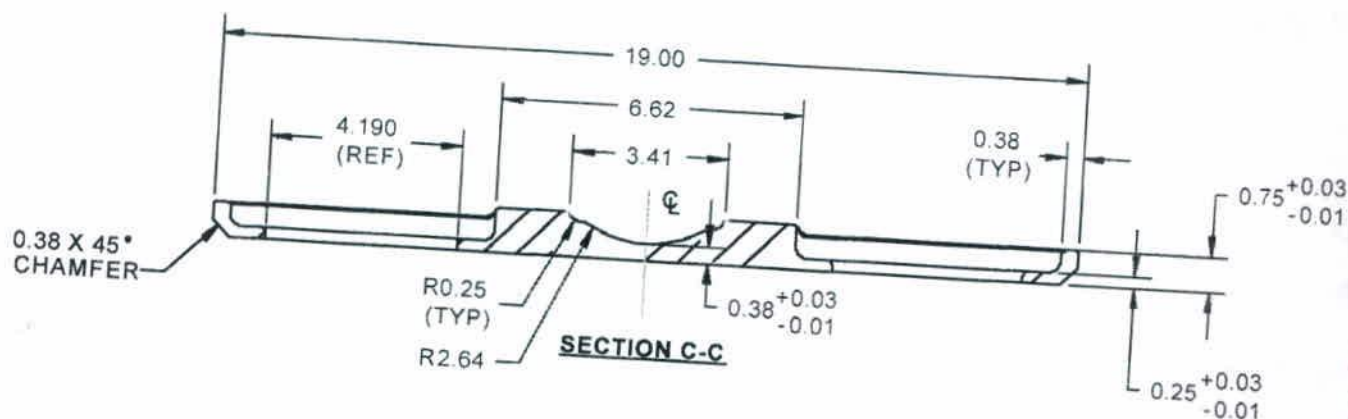
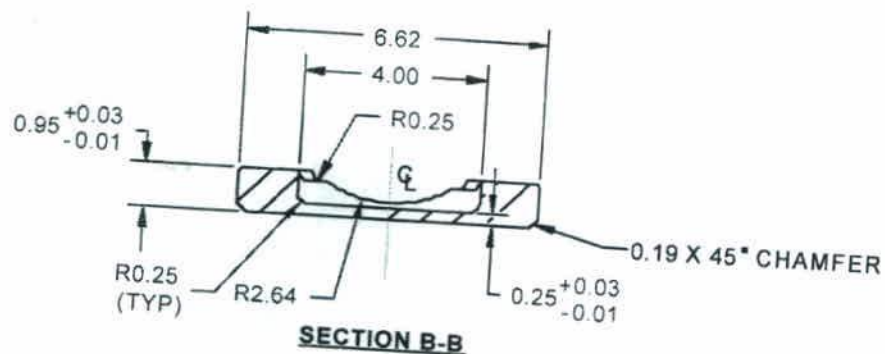
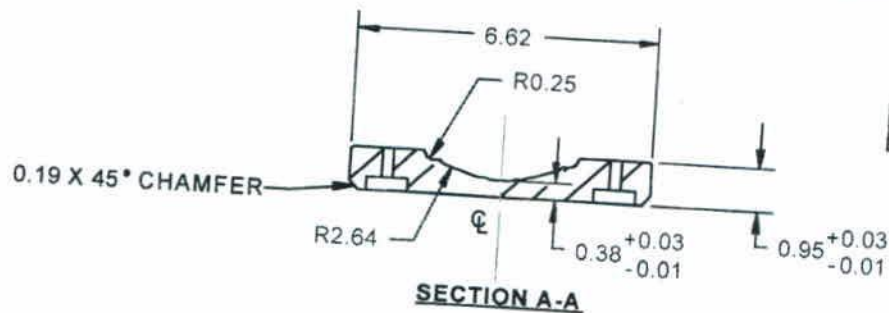
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DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2521	REV. J
DATE 06.07.28	TITLE 205 BEARPAW		SHEET 3 OF 3
			SCALE 1:4

RELEASED
06.08.23



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